

Date: Wednesday, 7/11/2007 2:47:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 33483	
Estimate Number : 12792	
P.O. Number : <i>N/A</i>	Part Number : D35665
This Issue : 7/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3566 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31421	Material : <i>N/A</i>
Written By : _____	Due Date : 7/18/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-03-08 ec	
Est Rev:B Added Drain Holes 07-07-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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*M 103/04*

Comment: Qty.: 1.1130 sf(s)/Unit Total : 22.2600 sf(s)
 NEOPRENE SHEET 0.063

B 07-07-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3566
 Dwg Rev: *B*
 Prog Rev: *B*

2-Deburr if necessary

B 07-07-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*B 07-07-17*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SP 07/07/17**Count**(20)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

*7/11/17 SP**(20x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:47:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 33483

Part Number: D35665

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

LD 07/07/03

Job Completion



U 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33483
Description: Gasket		Part Number:	D3566-5
Inspection Dwg: D3566	Rev: <i>AB</i> <i>PH 07.10.11</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

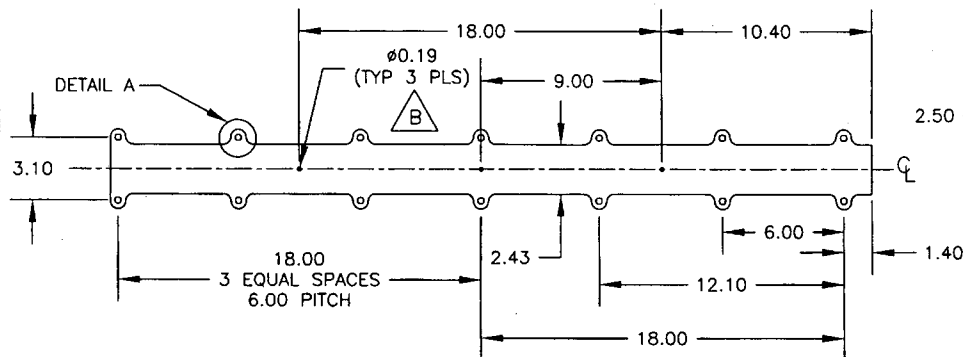
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50	<i>X</i>			
43.50	+/-0.030	43.50	<i>X</i>			
5.50 Pitch	+/-0.030	5.50	<i>X</i>			
2.50	+/-0.030	2.50	<i>X</i>			
2.43	+/-0.030	2.42	<i>X</i>			
3.10	+/-0.030	3.10	<i>X</i>			
2.50	+/-0.030	2.50	<i>X</i>			
0.30	+/-0.030	30	<i>X</i>			
0.30	+/-0.030	30	<i>X</i>			
0.063	+/-0.010	0.063	<i>X</i>			
6.75	<i>±/- 0.030</i>	6.75	<i>X</i>			
10.00	"	10.00	<i>X</i>			
20.00	"	20.00	<i>X</i>			
30.00	"	30.00	<i>X</i>			
6.75	±/- 0.030					
φ0.19	+/- 0.030	φ.19	<i>X</i>			

PH 07.10.11

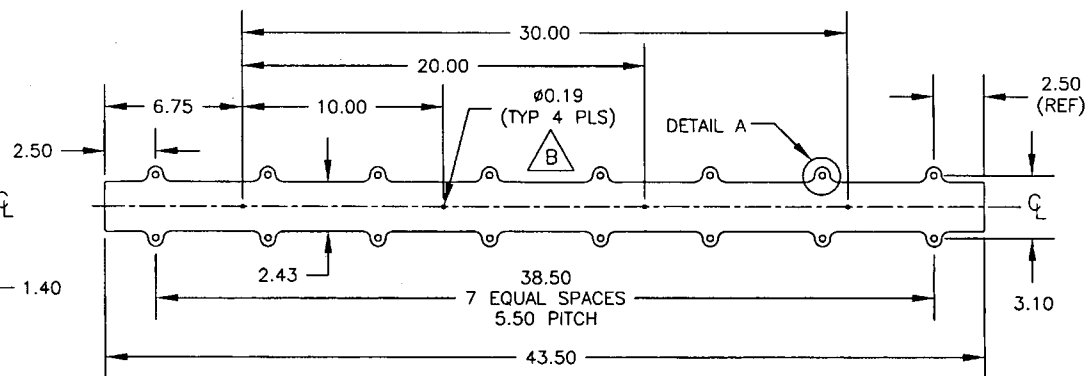
Measured by: <i>LB</i>	Audited by:	Prototype Approval:	N/A
Date: 07-07-11	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

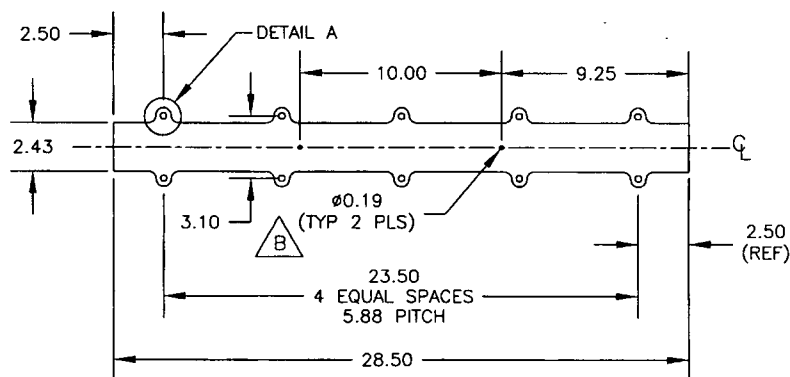
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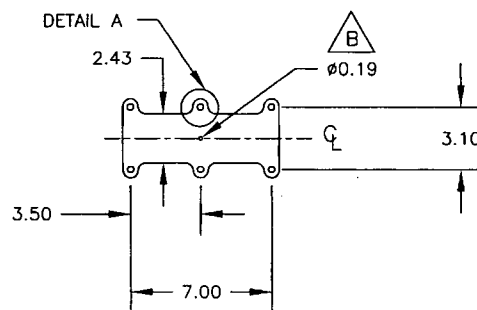
D3566-1 GASKET



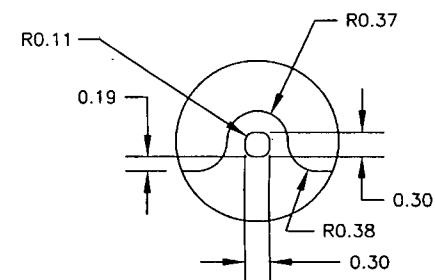
D3566-5 GASKET



D3566-7 GASKET



D3566-13 GASKET



DETAIL A
SCALE 1:2

D3566-1/-3/-5/-7/-13 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

WORK ORDER
33483
ENGINEERING
RETURN TO
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B	07.04.17	ADD DRAIN HOLES
A	06.12.18	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	07.04.17	TITLE
		GASKET
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D3566
		REV. B
		SHEET 1 OF 1
		SCALE 1:8

RELEASED
07.04.17